

6041 3/4



Dart Aerospace Ltd.
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Canada

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D5101-3

Job Sheet 203803



Part No: D5101-3

Job Qty: 60 pcs

100 pcs

Part Name: Insert



Part Weight: 0 lbs

Status: New

DAS
21
3-00

Priority: Medium

Job Created: 11/27/19

Job Tracking No:

Due Date: 12/6/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEET 3 IPP REV:A NEW ISSUE 14-12-18 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Doosan - 1	60 pcs		12/6/19	1.00	5.77	Doosan - 1			
120	QC 8	60 pcs		12/6/19	0.00	0.00	QC 8 - 12			
										19-12-03



Container No: S236834



Part: D5101-3

Job No: 203803

Serial No/Batch: S236834

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/03/19

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DEC 03 2019

				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	60 pcs	12/6/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	

DAS
82
9-89
DAS
81
9-89

160 Packaging 3-2 - Stock - B4B	60 pcs	12/6/19	0.00 0.00	QC 7 - 61	
				QC 7 - 81	DEC 17 2019
				QC 7 - 76	
				QC 7 - 79	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS 23 9-89
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS 21 9-89
170 QC 21 - SA	60 pcs	12/6/19	0.00 0.00	QC 21 - SA - 21	DEC 17 2019
				QC 21 - SA - 70	FPOO1
				QC 21 - SA - 53	

Part Op 100 - (Doosan Lathe)TURN AS PER FOLIO FB 357 ✓
Descriptions: 120 - (QC8- Inspect parts - second check)
130 - v(Chemical Conversion Coat per QSI005 4.1)
150 - (QC7-Inspect Chemical Conversion Coat)
160 - (Identify as per dwg & Stock Location: _____)
170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.750	6061-T6 Round Bar .750"	5.2200 ft (.087 ea)	100-Doosan - 1	5226576

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M6061T6R0.750	5	42	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Insert	0.257inches + 0.006 - 0.001	0.263 0.256	257	
2	Insert	0.563inches ± 0.010	0.573 0.553	.56	
3	Insert	0.160inches ± 0.030	0.190 0.130	.164	
4	Insert	0.500inches ± 0.030	0.530 0.470	.499	
5	Ineert	0.060inches ± 0.030	0.090 0.030	.06	

Plex 11/27/19 12:56 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)					
Description Work Order Deviation		Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Contamination ☐ Bending ☐ Misaligned/off center ☐ Crushing ☐ BOM/Route ☐ Cracks ☐ Broken/Damage/Defect ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Marks/Chatter ☐ Drill Holes ☐ Mislabeled ☐ Fit/Function ☐ Other/Details: _____				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
		Completed By _____				Lead hand / Supervisor _____			
		QC / QA Coordinator _____							